ROTACATOR
ADJUSTMENT JIG FOR PLANERS

Small Tip

Large Tip

Figure 1

Up-Reading Position

Figure 2

Down-Reading Position

Preparation

1. DISCONNECT PLANER FROM POWER!

2. Set knives in cutterhead with factory knife-setting jig.

3. Adjust opening between table and headstock to approximately 4". This gives you enough space to work with the Rotacator.
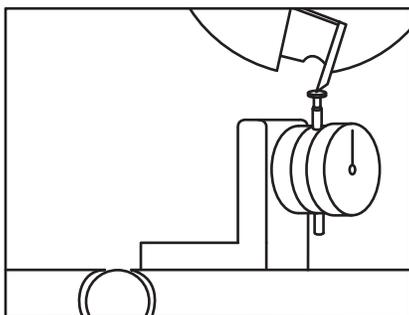
Adjusting Planer Bed Parallel to Planer Knives

1. Insert the large tip into the Rotacator.

2. Rotate dial indicator to "Up-Reading" position (see Figure 1).

3. Place dial indicator between table and cutterhead at one end of the cutterhead.

4. Gradually reduce opening space until the Rotacator plunger is slightly depressed by one of the knives. Make sure that knife is at the lowest point of its cutting arc.

5. Note the reading on the dial indicator face.

6. Remove dial indicator and place it in the same position at the opposite end of the knife. Read the dial indicator again. If the readings are not equal on both sides, adjust one side of the planer table until readings are the same.

Adjusting Bed Rollers

1. Insert the small tip into the Rotacator.

2. Rotate the dial indicator to the "Down-Reading" position (see Figure 2).

3. Place the dial indicator on the surface of the planer table.

4. Loosen the setscrew of the dial indicator, then rotate the face dial until the zero is aligned with the pointer. Tighten the setscrew.

5. Place the dial indicator on the surface of the planer bed so the plunger is touching the high point of one end of the bed roller.

6. Adjust roller height above table to the specifications in the planer owner's manual.

7. Repeat steps 4 and 5 at the opposite end of the same roller.

8. Repeat steps 4, 5 and 6 for the other bed roller.
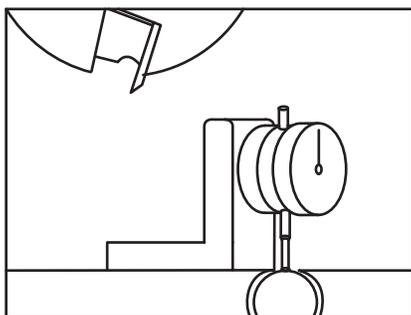
Adjusting Power Feed Rollers and Chip Breaker

1. Insert the small tip into the Rotacator.

2. Consult your planer instruction manual to determine the proper relationship of the infeed and outfeed rollers and chip breaker to the knives or cutterhead. Adjust as needed per the instruction manual.

Instructions for Model W1218A